

CLAIMS

Sub-B' →

1. A method of making an interior trim panel for attachment to structure of a vehicle, said method comprising the steps of:
- loading a trim blank into a cavity of a first side of a mold;
- depositing a molten thermoplastic material onto a core on the first side of the mold;
- closing the mold;
- moving the slide in a channel of the core;
- and
- injecting a molten thermoplastic material into a second side of the mold to form the interior trim panel.
2. A method as set forth in claim 1 wherein said step of injecting includes forming a carrier from the thermoplastic material and bonding the carrier to the trim blank.
3. A method as set forth in claim 1 wherein said step of depositing comprises extruding the thermoplastic material onto the core of the mold.

4. A method as set forth in claim 1 including the step of moving the slide to an extended position prior to said step of closing the mold.

5 5. A method as set forth in claim 1 wherein said step of moving the slide comprises moving the slide to a retracted position after said step of closing the mold.

10 6. A method as set forth in claim 1 wherein said step of loading comprises loading the trim blank into a slip device on the mold.

15 7. A method as set forth in claim 1 wherein said step of injecting comprises providing a fixed injection unit and injecting molten plastic into the mold.

20 8. A method as set forth in claim 7 including the step of cooling the interior trim panel.

9. A method as set forth in claim 8 including the step of opening the mold.

10. A method as set forth in claim 9 including the step of removing the interior trim panel from the mold.

5 11. A method as set forth in claim 1 including the step of pre-cutting the trim blank.

12. A method as set forth in claim 1 including the step of starting one step before a
10 previous step has been completed.

Sub B² 13. A method of making an interior trim panel for attachment to an inner panel of a vehicle, said method comprising the steps of:

15 loading a trim blank into a cavity of a mold on a first side thereof;

depositing a molten thermoplastic material onto a core of the mold on the first side thereof;

closing the mold to form a first portion of
20 the interior trim panel;

moving the slide in a channel of the core;

and

injecting a molten thermoplastic material into the mold and forcing the molten plastic material

into a second side of the mold to form a second portion of the interior trim panel.

14. A method as set forth in claim 13
5 wherein said step of injecting includes forming a carrier from the thermoplastic material and bonding the carrier to the trim blank.

15. A method as set forth in claim 13
10 wherein said step of depositing comprises extruding the thermoplastic material onto the core of the mold.

16. A method as set forth in claim 13
wherein said step of loading comprises loading the trim
15 blank into a slip device on the mold.

17. A method as set forth in claim 13
wherein said step of moving the slide comprises
retracting the slide to a retracted position after said
20 step of closing.

Sub B³ 18. A method as set forth in claim 17
including the step of opening the mold.

19. A method as set forth in claim 18 including the step of removing the interior trim panel from the mold.

5 *Sub B⁴* 20. A method of making a door trim panel for attachment to an inner panel of a door of a vehicle, said method comprising the steps of:

loading a trim blank into a cavity of a mold on a first side thereof;

10 depositing a molten thermoplastic material onto a core of the mold on the first side thereof;

closing the mold to form a first portion of the interior trim panel;

moving the slide into a channel of the core;

15 and

injecting a molten thermoplastic material into a second side of the mold and forcing the molten plastic material into the second side of the mold to form a second portion of the door trim panel.

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